

5/44

DART AEROSPACE LTD	Work Order:	24267
Description: Bracket Assembly	Part Number:	D3137-043
<i>04.08.30</i> <i>04.08.30</i>		
Dwg: D3137 Rev. <i>01.02.29</i>	Qty:	3 <i>KH</i>
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04.02.27

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	<i>05.09.14</i>	<i>05.09.14</i>	3																				
2	MV	Cut blank: (2.000" x 0.500") 5.570" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B0.500x02.000) Identify for D3137-7 Batch: <i>M14773</i>	<i>MS</i>	<i>05/10/17</i>	3																				
3	MV	Machine D3137-7 as per Folio FA338 and Dwg D3137 Identify as D3137-7	<i>36/</i>	<i>05.10.18</i>	3																				
4	QC2	Inspect parts as they come off the CNC machine	<i>36/</i>	<i>05/10/18</i>	3																				
5	MV	Deburr	<i>36/</i>	<i>05/10/18</i>	3																				
6	MV	Scribe batch number	<i>36/</i>	<i>05/10/18</i>	3																				
7	QC8	Second check	<i>36/</i>	<i>05.10.19</i>	3																				
8	GA	Assemble D3137-043 as per Dwg D3137. (Note: D3137-7 is on BOM as material from Steps 2). Pick: <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>1</td> <td>D3137-3</td> <td>Guide</td> <td><i>B 23709</i></td> </tr> <tr> <td>1</td> <td>D3137-5</td> <td>Washer</td> <td><i>B 24547</i></td> </tr> <tr> <td>1</td> <td>D3137-7</td> <td>Bracket</td> <td><i>B 24267</i></td> </tr> <tr> <td>1</td> <td>MS24694-S101</td> <td>Screw</td> <td><i>M 16941</i></td> </tr> </table> Identify as D3137-043	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D3137-3	Guide	<i>B 23709</i>	1	D3137-5	Washer	<i>B 24547</i>	1	D3137-7	Bracket	<i>B 24267</i>	1	MS24694-S101	Screw	<i>M 16941</i>	<i>SB</i>	<i>05/11/29</i>	3
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																						
1	D3137-3	Guide	<i>B 23709</i>																						
1	D3137-5	Washer	<i>B 24547</i>																						
1	D3137-7	Bracket	<i>B 24267</i>																						
1	MS24694-S101	Screw	<i>M 16941</i>																						
9	QC5	Inspect work to Step 8	<i>2</i>	<i>05.11.29</i>	3																				
10	ST	Identify and Stock	<i>Lucy</i>	<i>05/11/30</i>	3																				
11	AC	Cost / part																							
12	DC	Close W/O Inspect Level 21	<i>9</i>	<i>05/12/01</i>	3																				

02

Rev	Date	Change	Revised By	Approved
<i>AB</i>	04.02.18	New issue	KJ/DS	<i>04.02.19</i>

04.02.19

RELEASED
04.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 05/10/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 24267
Description: Bracket		Part Number: D3137-7
Inspection Dwg: D3137	Rev: C2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	0.422	✓			
0.615	+/-0.010	0.620	✓			
0.200	+/-0.010	0.198	✓			
0.380	+/-0.010	0.385	✓			
0.262	+/-0.010	0.270	✓			
Ø0.500	+0.005/-0.000	0.504	✓			
0.79	+/-0.030	0.795	✓			
2.79	+/-0.030	2.77	✓			
Ø0.560	+0.005/-0.000	0.564	✓			
0.595	+/-0.010	0.588	✓			
0.950	+/-0.010	0.949	✓			
0.605	+/-0.010	0.607	✓			
1.880	+/-0.010	1.880	✓			
2.48	+/-0.030	2.486	✓			
4.975	+/-0.010	4.974	✓			
5.41	+/-0.030	5.413	✓			
0.032	+/-0.010	0.030	✓			
0.063	+/-0.010	0.062	✓			
R0.062	+/-0.010	0.062	✓			
0.162	+/-0.010	0.161	✓			

Measured by: EP	Audited by: BG	Prototype Approval:	N/A
Date: 05/10/18	Date: 05.10.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	

RELEASED